

Date: Thursday, 2/23/2006 10:24:25 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STA 84 BRACKET
Job Number	: 25928		
Estimate Number	: 11034 0	Part Number	: D28031
P.O. Number	: NIA	Drawing Number	: D2803 REV B
This Issue	: 2/23/2006 S.O. No. : NIA	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: B
First Issue	: NIA Type : MACHINED PARTS	Material	: NIA
Previous Run	: NIA	Due Date	: 3/22/2006 Qty: 10 Um: Each
Written By	: <i>See COMMENT Below</i>		
Checked & Approved By	: <i>06.02.23</i>		
Comment	: Est. A00.11.06 New Issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X10000	6061-T6 Bar .50" x 10.0"
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Comment: Qty.: 2.0125 f(s)/Unit Total: 20.1254 f(s)

6061-T6 Bar .50" x 10.0"

Material: 6061-T6 bar 10.00" x 0.50"

Batch: *M18031**ml 06/03/05 10*

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks per template DT8533

ml 06/03/05 10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA102

ml 06/03/05 10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/03/05 10

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

ms 06/03/06

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr

ml 06/03/05 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PD Date: 06/03/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/23/2006 10:24:25 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 84 BRACKET

Job Number: 25928

Part Number: D28031

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

J.L 06.03.06 10

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06:03:06 10

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/03/14 10

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/03/14 10

Job Completion



W 06.03.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 25928
Description: Bracket		Part Number: D2803-1
Inspection Dwg: D2803 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.625	+/-0.010					
Ø0.757	+0.005/-0.000	Ø0.759	✓			
Ø0.191	+0.005/-0.000	Ø0.192	✓			
Ø0.507	+0.000/-0.001	Ø0.507	✓			
13.558	+/-0.010	13.558	✓			
Ø0.507	+0.000/-0.001	Ø0.507	✓			
12.411	+/-0.010	12.411	✓			
2.654	+0.000/-0.001	2.654	✓			
0.437	+0.000/-0.001	0.436	✓			
1.420	+/-0.001	1.420	✓			
6.933	+/-0.010	6.931	✓			
0.250	+/-0.010	0.249	✓			
0.875	+0.000/-0.001	0.875	✓			
0.250	+0.000/-0.005	0.250	✓			
0.125	+/-0.010	0.124	✓			
0.125	+/-0.010	0.117	✓			
0.125	+/-0.010	0.119	✓			
0.125	+/-0.010	0.121	✓			
0.500	+/-0.010	0.498	✓			
0.562	+/-0.010	0.561	✓			
0.188	+/-0.010	0.186	✓			

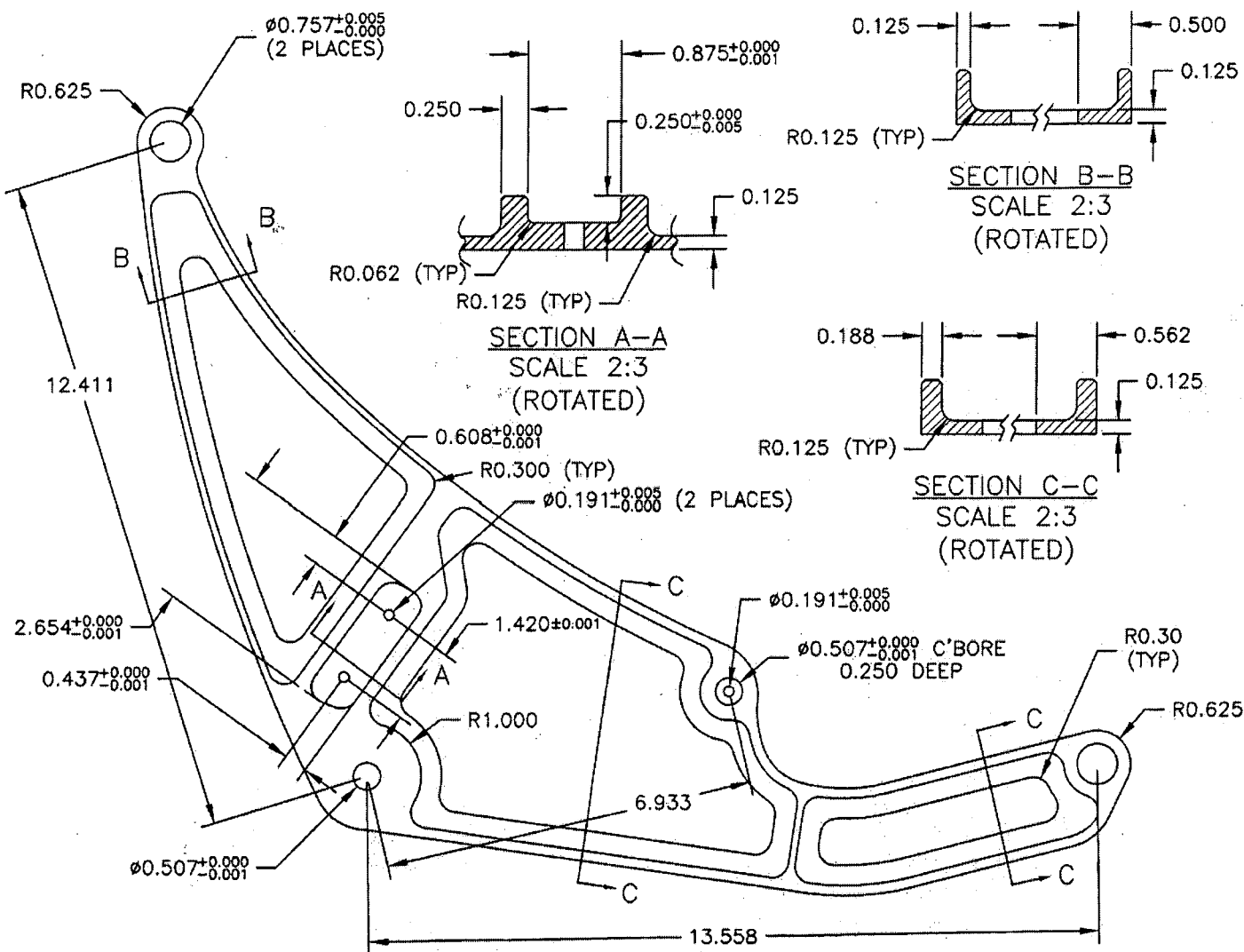
Measured by: <i>gml</i>	Audited by: <i>NB</i>	Prototype Approval:	N/A
Date: 06/03/05	Date: 06/03/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	SHEET 1 OF 2
				D2803	
DATE	04.11.22			TITLE	SCALE
				STA 84 BRACKET	1:3
A	00.11.07			NEW ISSUE	
B	04.11.22			ADD CUTOUTS & -043/-044	

RELEASED

05.03.11 *[Signature]***D2803-1 BRACKET (SHOWN), D2803-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

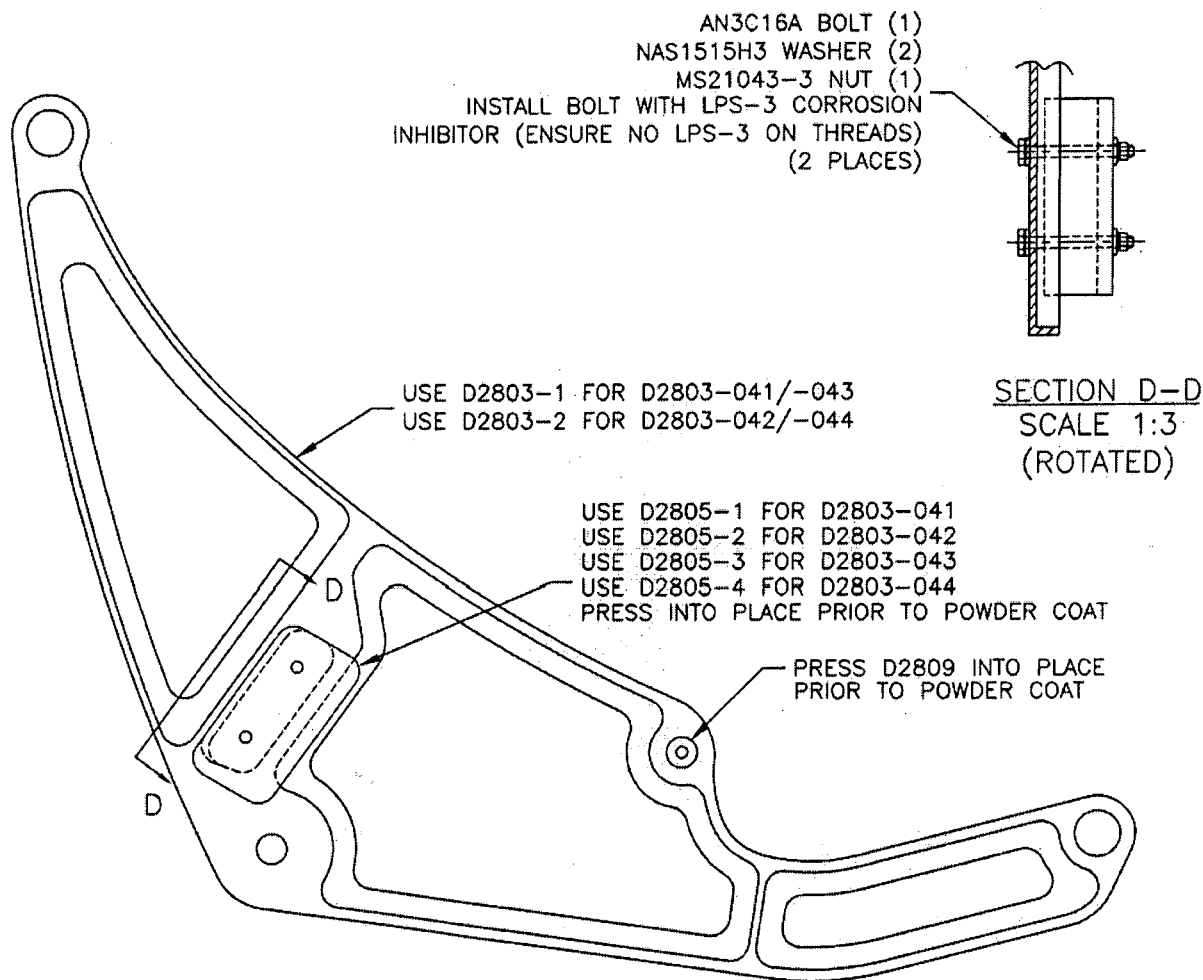
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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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